

REFERENCE 1A

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLADE POSITIONER

Job Number: 41295

Part Number: PB674300127

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

MS27039109

Screw



Comment: Qty.: 7.0000 Each(s)/Unit Total: 28.0000 Each(s)

Screw

batch:

107378

JS 08/09/23 (x4)

14.0

NAS1149F0316P

WASHER



Comment: Qty.: 7.0000 Each(s)/Unit Total: 28.0000 Each(s)

WASHER

batch:

108473

- not in comp. old batch JS 08/09/23 (x4)

15.0

MS27039104

Inventory



Comment: Qty.: 3.0000 Each(s)/Unit Total: 12.0000 Each(s)

Inventory

batch:

18431

JS 08/09/23 (x4)

16.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: 1- slide -289, -291 and -293 on -19 tube then slide it in -285 tube

2- drill holes 0.159 (#21) thru -285 into -289 in (3) place and tap 10-32 UNF as per dwg

3- assemble all parts as per dwg PB67-43001

M-F / FJ

Cpl 08-10-22

17.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/10/22 (x4)

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

P. 08/10/22 (4)

19.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/10/22 (x4)

Job Completion



MF 08-10-22

Add 960-16-Washer m5519 Qty-12

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLADE POSITIONER

Job Number: 41295

Part Number: PB674300127

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PB6743001293

Extension Tube Adjustmnt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)
Extension Tube Adjustmnt
batch: B40061

mf 08/09/23 (4)

7.0

PB6743001289

Handle Adjustmnt Fitting



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)
Handle Adjustmnt Fitting
batch: 41375

mf 08/09/23 (4)

8.0

PB6743001291

Clamp Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)
Clamp Bushing

B 40060

mf 08/09/23 (4)

9.0

AN622A

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)
BOLT
batch: m18057

SS 08/09/23 (4)

10.0

NAS1149F0632P

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)
WASHER
batch: 18057

SS 08/09/23 (4)

11.0

MS518598

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)
WASHER
batch: 108986

SS 08/09/23 (4)

12.0

MS21042L6

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)
Nut
batch: 105077

SS 08/09/23 (4)

Date: Tuesday, 23/09/2008 9:53:12 AM
 User: Melanie Fauteux

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BLADE POSITIONER
Job Number	: 41295		
Estimate Number	: 13530		
P.O. Number	:	Part Number	: PB674300127
This Issue	: 23/09/2008 S.O. No. :	Drawing Number	: B6743001 P.4
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 18/08/2008 Type : SMALL /MED FAB	Drawing Revision	: B1
Previous Run	: 41241	Material	:
Written By	:	Due Date	: 15/09/2008
Checked & Approved By	: <u>mf 08-09-23</u>	Qty:	<u>4</u> Um: Each
Comment	: Est Rev:A 08-07-29 new issue DD verified by:ec		

Additional Product AN960-10 → WASHER M5519 → 18 Qty CPL 08-10-21
PB674300135 → ADD CONTACT CEMENT → M109109

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PB674300135	PB67-43001-35 Lower Pad Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)
 PB67-43001-35 Lower Pad Assembly
 batch: B41378

— Add contact cement
M109109

mf 08-10-21

2.0	PB674300131	PB67-43001-31 Upper Restraint Weldment
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)
 PB67-43001-31 Upper Restraint Weldment
 batch: B41378

41377 x 2

mf 08-10-21

3.0	PB674300129	PB67-43001-29 Blade Positioner Weldment
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)
 PB67-43001-29 Blade Positioner Weldment
 batch: B41378

41376 x 2 mf 08-10-21

4.0	PB6743001285	PB67-43001-285 Upper Tube
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)
 PB67-43001-285 Upper Tube
 batch: 41374

mf 08-10-21

5.0	PB674300119	PB67-43001-19 Inner Tube and Retainer Bu
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)
 PB67-43001-19 Inner Tube and Retainer Bu
 batch: 41369

mf 08-10-21